

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-028228**Date Inspected:** 24-Aug-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 1100**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1930**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** As noted below.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

Quality Assurance Inspector (QA) William Clifford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

**Tower In- Process**

This QA randomly observed ABF/JV qualified welder Xiao Hua Lu #1291 performing Shielded Metal Arc Welding (SMAW) with 3.2mm" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-F1200A. The joint being welded was a 10mm fillet weld at Tower Doubler Plate designated as P1128-A22.

During welding, ABF Quality Control (QC) Andrew keech was noted monitoring the welding parameters. Welding parameters were recorded as (A=131).

**Electroslag Weld Excavation**

This QA observed ABF/JV welding personnel James Zhang #6001 performing excavation of an Electroslag Weld (ESW) repair previously Magnetic Particle Tested (MT) by Quality Control (QC) technicians.

The MT discovered indication was found to be oriented in the longitudinal position along the toe of the repair weld.

The weld being excavated is designated as "ESW F" and was excavated on Face B at location:  
Weld "F" – Y= 3320mm.

The carbon arc gouging process, as well as machine grinding, are being used to excavate this weld. At random intervals both QA and QC performed Magnetic Particle Testing (MT) to determine if the rejectable indication had

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been removed.

This excavation is in-process and final measurements have not been taken.

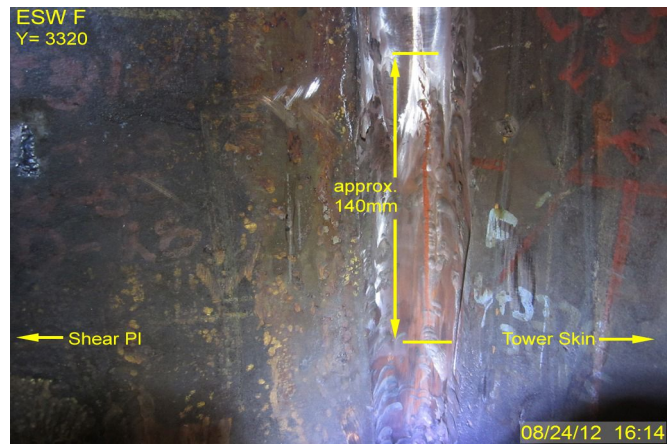
Please see attached photographs for more information.

## ESW RWR Tracking

This QA was instructed by Task Leader Bill Levell to generate a spread sheet for the tracking of Request for Weld Repair (RWR) forms submitted by ABF for the repair of Electroslag Welds located at the base of the Tower.

This assigned task requires review of all submitted RWR's as well as review of approved QA TL-6031 report forms applicable to this welding, testing, and repair. This QA used the balance of time not allocated for in-process inspection and testing to work on this task.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



## Summary of Conversations:

Conversations were relevant to work performed.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Clifford, William	Quality Assurance Inspector
<b>Reviewed By:</b>	Levell, Bill	QA Reviewer

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